

# Work Order ID 73618

Wednesday, September 07, 2011 2:35:52 PM



Page 1

Item ID: D3443-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tubing

Start Date: 9/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
----------	--------------

D3443	Rev C
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100



NC BRAKE

Set Up/ Run Hours
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Tool ID
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Tool #
--------

Plan Code
--------------

Accept Qty
---------------

Reject Qty
---------------

Reject Number
------------------

Insp. Stamp
----------------

Brake NC
----------

Memo

0.00

8

φ

Brake NC
----------

1- Form as per Dwg D3443 using DT8117 2- Deburr per dwg D3443

*to 11-11-02*

SB 11/11/07

110



Small Fab

0.00

Small Fab
-----------

Memo

0.00

Small Fab
-----------

GRIND RAD PER DWG

*to 11-11-02*

120



QC5- Inspect part completeness to step on W/O

0.00

QC
----

Memo

0.00

*SW 11/11/07*

*+8*

φ

Quality Control
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73618**

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Item ID: D3443-7

Accept



Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 9/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Mill Conv

CONVENTIONAL MILLING MACHINE

0.00

0.00

*✓ 4/12/19 8 φ*

Memo

Conventional Milling Machine

1 - Mill end to lenght and drill hole as per dwg D3443 2-Deburr as per dwg  
D3443*\*check total length before milling \**

140



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

*✓ 4/12/19 8 φ*

Quality Control

150



QC8- Inspect parts - second check

0.00

0.00

*B.a 4/12/19 8 φ*

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73618**

Wednesday, September 07, 2011 2:35:53 PM



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Item ID: D3443-7

Accept



Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 9/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

160

Identify as per dwg & Stock Location: WASet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

11/12/2010

D 82

Packaging

Memo

0.00

Packaging

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/12/2010

11/12/2010  
(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, September 07, 2011 2:35:50 PM

Page 1

Work Order ID: 73618



Parent Item: D3443-7



Parent Item Name: Tubing

Start Date: 9/7/2011

Required Date: 9/22/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: A 05.11.14 New issue ECH

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No			100	f	56.0000	0.75	6.315789			

304 ss round tube .750 x .120w



Location	Loc Qty	Loc Code
MAT017 <u>m119160</u>	56.00000027	<u>5</u>
114706	0.00000027	
<u>118390</u>	56	<u>1</u>

Ac 11.11.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 73618

Description: Tubing

Part Number: 3443-7

Inspection Dwg: 9443 Rev: C

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article       Prototype

Measured by: 

Audited by: H.

Prototype Approval

Date: 11/12/19

Date: 11/12/19

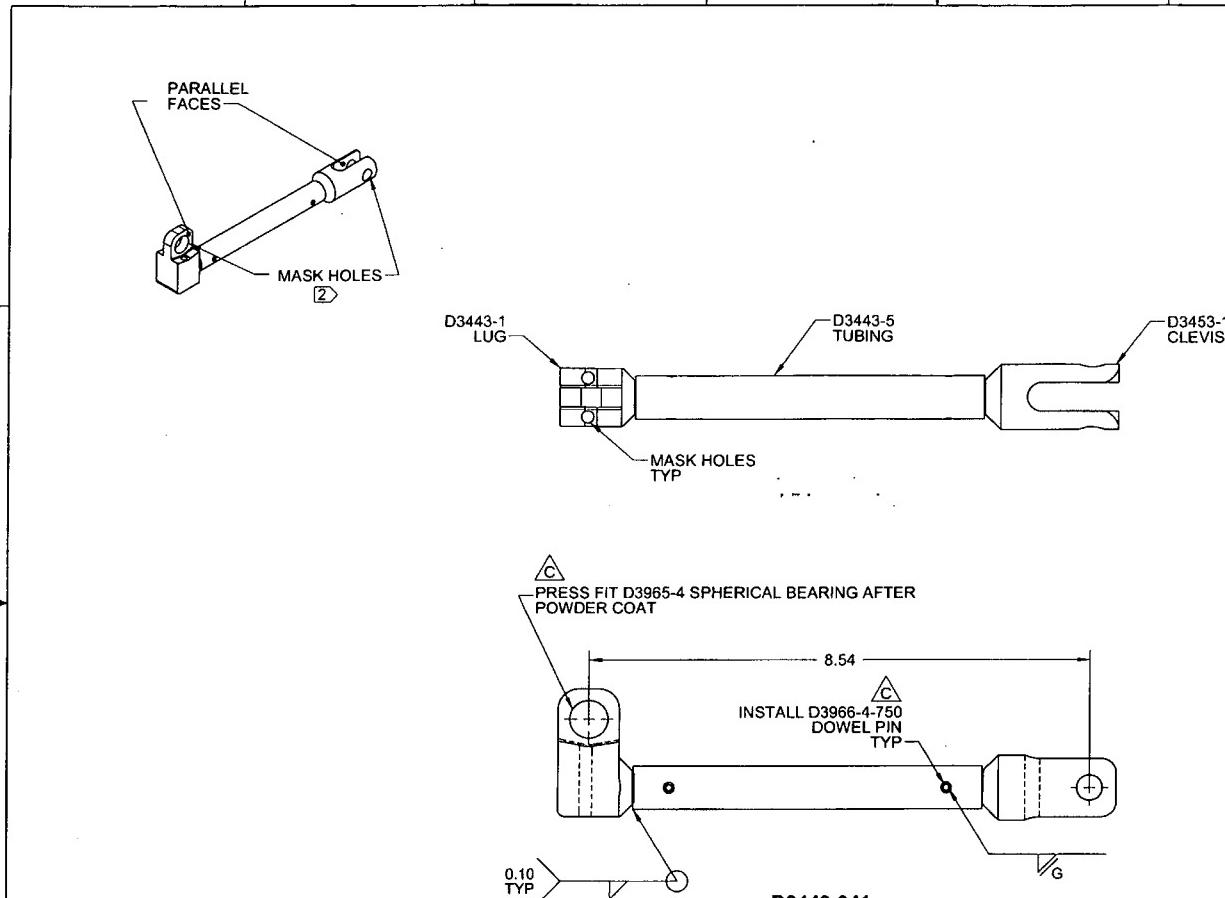
Date: \_\_\_\_\_

Rev	Date	Change
A		New Issue

— 1 —

Revised by      Approved  
K U M

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART PIN USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.33 lbs
  - 8) WELD PER DART QSI 004

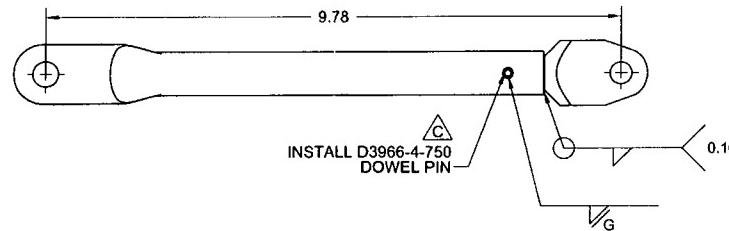
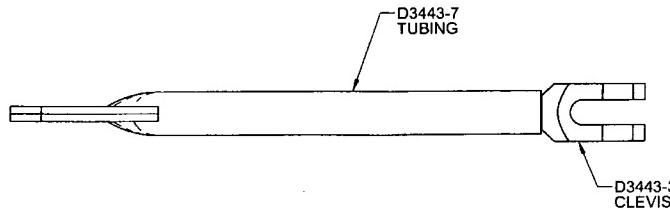
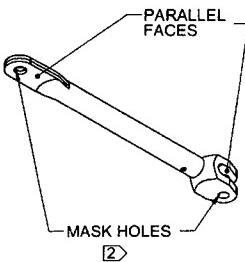
C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2), 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER PIN (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR PIN (ZN B5-1); REF PAR 09-018		
RF	09.06.25		
B	ADDED -8 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø 0.125 WAS #30		
RF	05.12.05		
A	NEW ISSUE		
RF	05.09.02		
REV.	DESCRIPTION		
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. C	
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	
DATE	09.06.25	NTS	

*[Handwritten note: MB 73618]*

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8 7 6 5 4 3 2 1

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



RELEASED  
07/08/2014

7/8/18  
D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. C	
MFG. APPR.		DRAWING NO. D3443 SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE STRUT WELDMENT ASSEMBLY	
DE APPR.	<i>[Signature]</i>	SCALE	
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